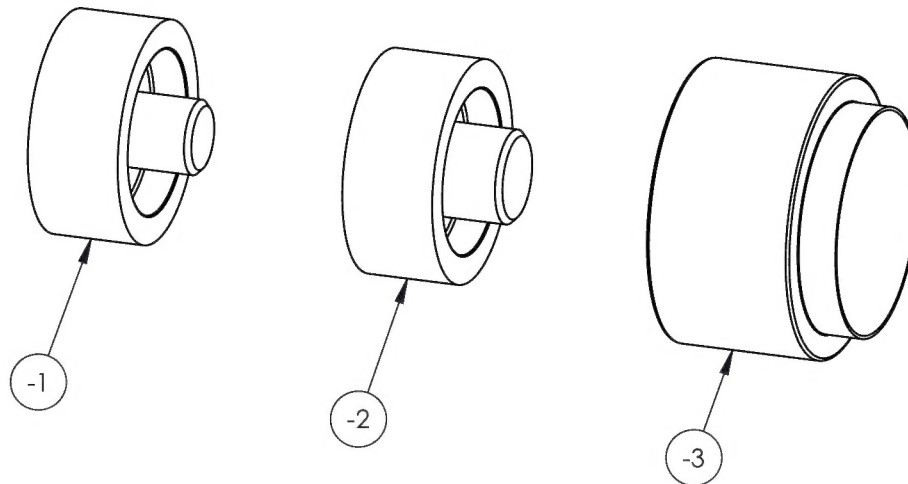


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| REVISIONS | | | | | |
|-----------|---------|---|------------|---------|----------|
| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
| 1 | | PARTS COUNT REDUCED: -6 ELIMINATED, -4 ID REDUCED TO Ø.995, -4 QTY INCREASED TO TWO, -5 STEP OD REDUCED TO Ø.995. | 6/10/2004 | | |
| 2 | | ADDED -3 AND -4 ROUGHING DETAILS, CHANGED -4 QTY TO 1. | 7/7/2006 | | |
| 3 | | -4 ADDED CHAMFER 45° AND LIMITS, CH'D DIM .996 TO .998 & P.F. -.7, COMBINED PG'S 2 & 3, 4 & 5, 6 & 7, 8 & 9. | 4/27/2009 | RJC | |
| 4 | | CH'D -5 FINISH DETAIL FROM Ø.995 +.001 -.000 TO Ø1.000 +.001 -.000, CH'D -7 FINISH DETAIL FROM Ø.998 +.001 -.000 TO Ø.999 +.001 -.000 & ADDED MISSING Ø1.000 +.001 -.000 P.F. -.4 PER G.E. ADDED -.9 PER RW. | 10/24/2011 | RJC | RW |
| 5 | 15-0133 | UPDATED TO NEW DRAFTING STANDARDS. -1 & -2 ADDED ASSY. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS. | 6/8/2015 | DPD | JAG |
| 6 | 17-0047 | UPDATED TO NEW DRAFTING STANDARD. -1, -2 ADDED FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D, -3 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, -4 CH'D FINISH WAS BLACK OXIDE IS SEE -1 & -2, -5 C'D DIM WAS .25 IS .28, WAS 1.50 IS 1.53, ADDED DIM 1.50, CH'D FINISH WAS BLACK OXIDE IS SEE -1, -7 CH'D DIM'S WAS .25 IS .28, WAS 1.50 IS 1.53, ADDED DIM'S .250, 1.50. CH'D FINISH WAS BLACK OXIDE IS SEE -2. | 2/28/2017 | RJC | JAG |



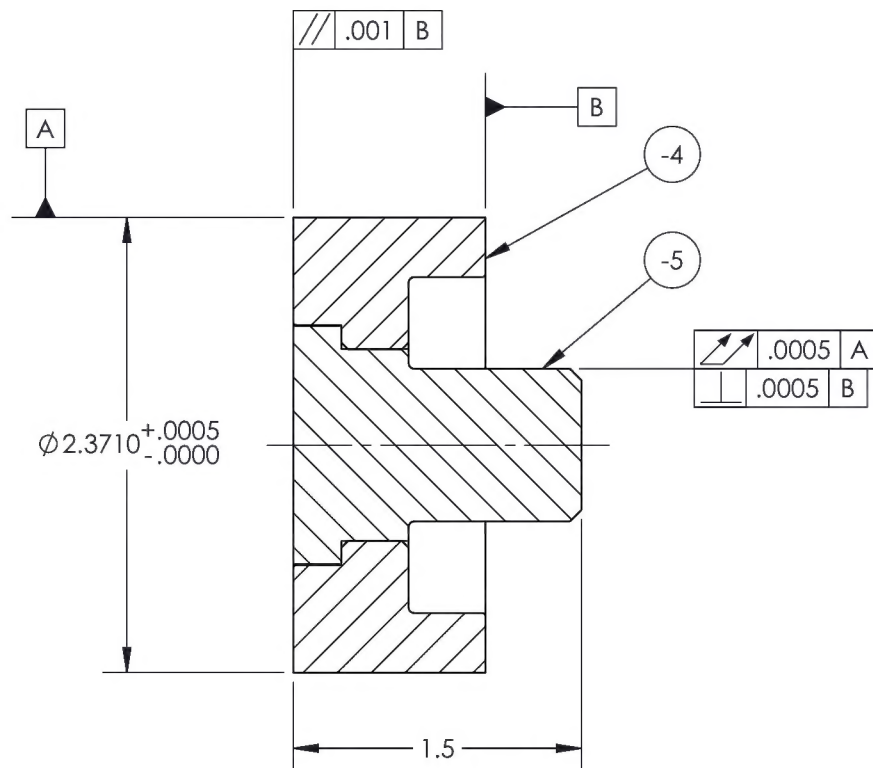
NOTE:
SIMILAR TO 269T9320.

| | |
|--|---------------------------|
| DART AEROSPACE | |
| TITLE STAKING TOOL T/R PITCH CONTROL | |
| DWG NO. RB0006-809-00088 | REV 6 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓ | |
| 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R | |
| 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | |
| 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 | |
| USED ON MODEL MD 500 | |
| DRAWN BY: COLE CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT | |
| SCALE 1:2 | DATE 12/10/2004 |
| SHEET 1 OF 7 | |

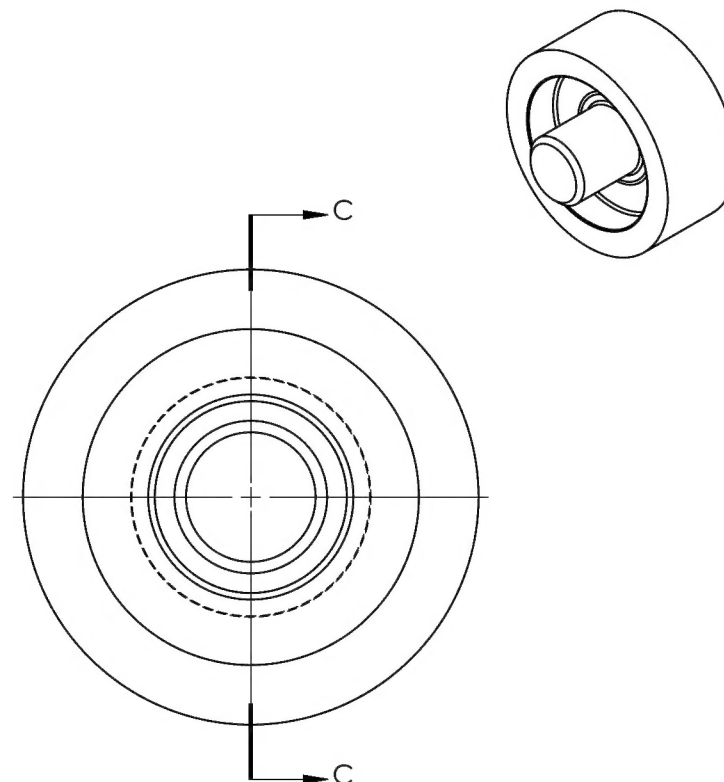
| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description | Material | B/O INFORMATION OR SPECIFICATIONS | PG. |
|----------|----------|-----|--------|----------|----------------|----------|-----------------------------------|-----|
| | X | | -1 | 1 | GUIDE ASSEMBLY | | | 2 |
| X | | | -2 | 1 | GUIDE ASSEMBLY | | | 3 |
| | | | -3 | 1 | PUNCH | O-1 | | 4 |
| 1 | 1 | | -4 | | PILOT | O-1 | | 5 |
| | 1 | | -5 | | GUIDE | O-1 | | 6 |
| 1 | | | -7 | | GUIDE | O-1 | | 7 |
| | | B/O | -9 | 1 | PISTOL CASE | PLASTIC | SMALL (RSR GROUP #10137) | N/S |
| ASSY -2 | ASSY -1 | | | | | | | |

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| REVISIONS | | | | | |
|-----------|---------|--|-----------|---------|----------|
| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
| 5 | 15-0133 | -1 ADDED ASSY. | 6/8/2015 | DPD | JAG |
| 6 | 17-0047 | -1 ADDED FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D. | 2/28/2017 | RJC | JAG |



SECTION C-C

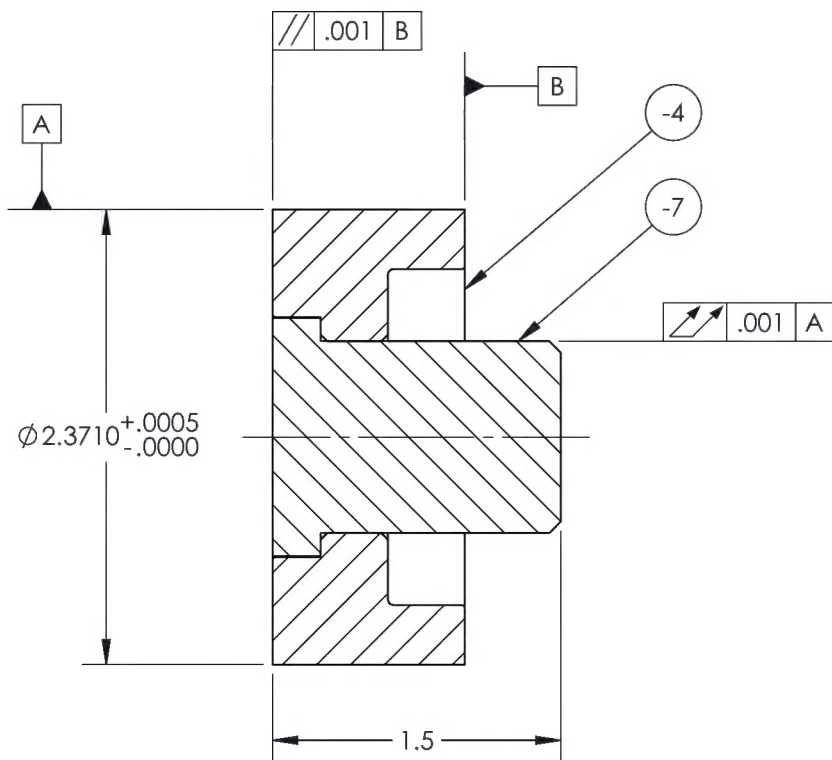


(-1)
GUIDE ASSEMBLY

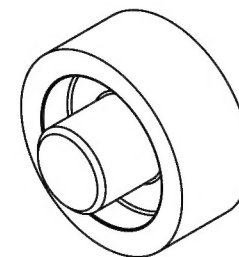
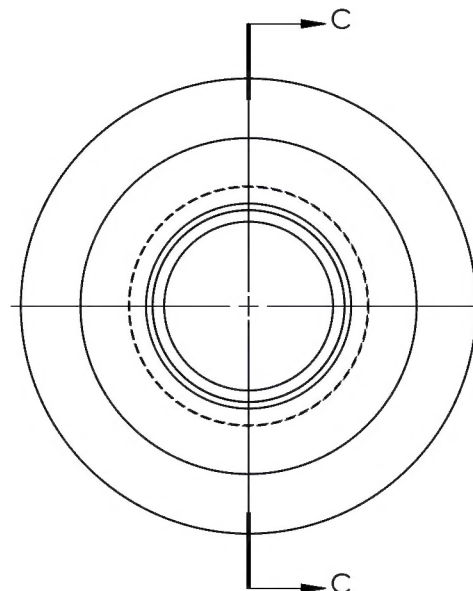
| | |
|---|---|
| DART AEROSPACE | |
| TITLE STAKING TOOL T/R PITCH CONTROL | |
| DWG NO. RB0006-809-00088-1 | REV 6 |
| MAT'L HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D | |
| DRAWN BY: COLE CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 |
| USED ON MODEL MD 500 | |
| SCALE 1:1 | DATE 12/10/2004 |
| SHEET 2 OF 7 | |

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| REVISIONS | | | | | |
|-----------|---------|--|-----------|---------|----------|
| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
| 5 | 15-0133 | -2 ADDED ASSY. | 6/8/2015 | DPD | JAG |
| 6 | 17-0047 | -2 ADDED FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D. | 2/28/2017 | RJC | JAG |



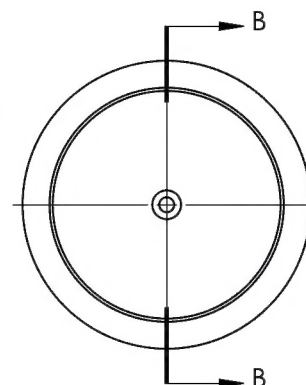
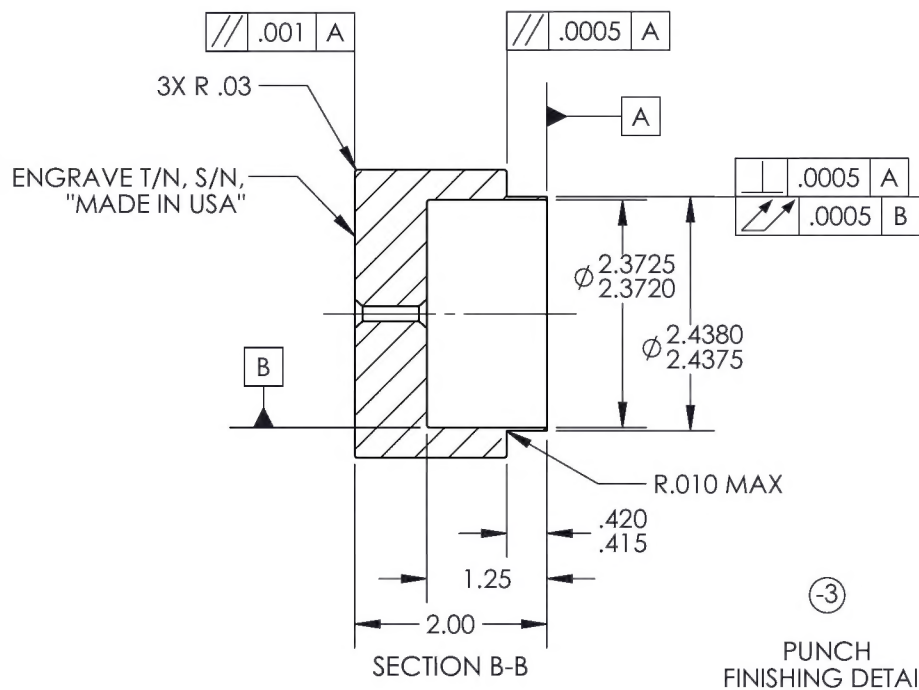
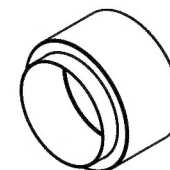
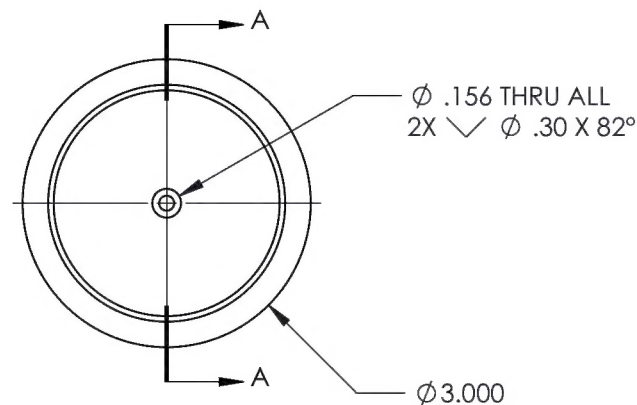
SECTION C-C




(-2)
GUIDE ASSEMBLY

| | |
|--|---|
| DART AEROSPACE | |
| TITLE STAKING TOOL T/R PITCH CONTROL | |
| DWG NO. RB0006-809-00088-2 | REV 6 |
| MAT'L REPT TREAT FINISH SPEC | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° |
| DRAWN BY: COLE | 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R |
| CHECKED: DUERFELDT | 2. DIMENSIONAL LIMITS APPLY AFTER PLATING |
| OPPS APPR: ANDERSON | 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 |
| QA APPR: LINDSAY | USED ON MODEL |
| APPROVED: GILBERT | MD 500 |
| SCALE 1:1 | DATE 12/10/2004 |
| SHEET 3 OF 7 | |

| REVISIONS | | | | | |
|-----------|---------|--|-----------|---------|----------|
| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
| 2 | | ADDED -3 ROUGHING DETAIL. | 7/7/2006 | | |
| 6 | 17-0047 | -3 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. | 2/28/2017 | RJC | JAG |

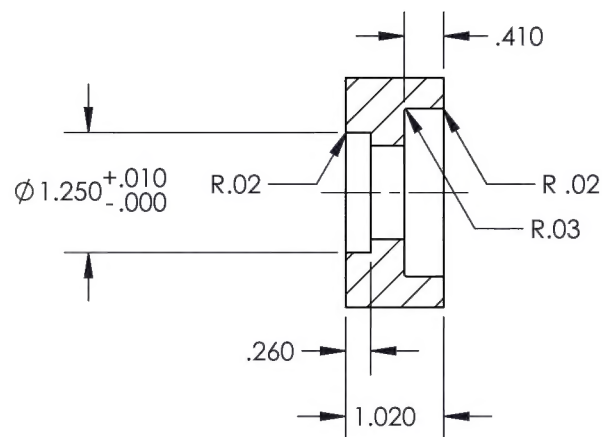


NOTE:
MUST MEET DIMENSIONAL LIMITS AFTER HEAT TREAT.

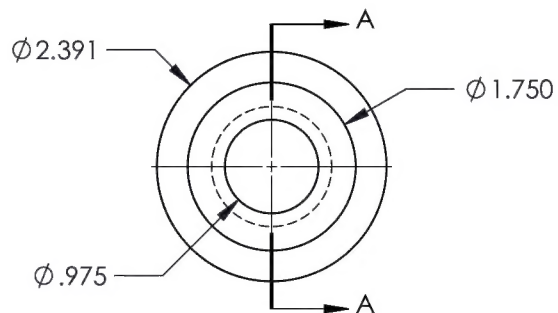
| | | | |
|---|-----|---|------------|
|  | | | |
| TITLE | | | |
| STAKING TOOL T/R PITCH CONTROL | | | |
| DWG NO. | | | REV |
| RB0006-809-00088-3 | | | 6 |
| MAT'L O-1 | | UNLESS OTHERWISE SPECIFIED | |
| HEAT TREAT RC 55-60 | | DIMENSIONS ARE IN INCHES | |
| FINISH BLACK OXIDE | | .XXX ± .005 FRACTIONS ± 1/8 | |
| SPEC QMSI-6.2.2, B.O. REV D | | .XX ± .01 ANGLES ± 5° | |
| | | .X ± .1 SURFACES = 125/√ | |
| DRAWN BY: COLE | | 1. BREAK ALL SHARP EDGES | |
| CHECKED: DUERFELDT | | .015 x 45° OR .015R | |
| OPPS APPR: ANDERSON | | 2. DIMENSIONAL LIMITS APPLY | |
| QA APPR: LINDSAY | | AFTER PLATING | |
| APPROVED: GILBERT | | 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 | |
| | | USED ON MODEL | |
| | | MD 500 | |
| SCALE | 1:2 | DATE | 12/10/2004 |
| | | SHEET 4 OF 7 | |

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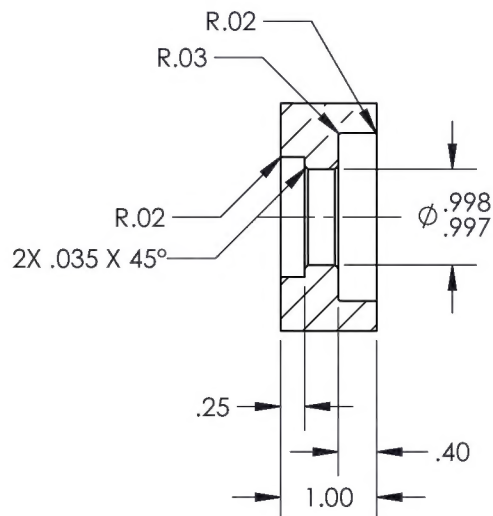
| REVISIONS | | | | | |
|-----------|---------|--|-----------|---------|----------|
| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
| 1 | | -4 ID REDUCED TO Ø.995. | 6/10/2004 | | |
| 2 | | ADDED -4 ROUGHING DETAIL | 7/7/2006 | | |
| 3 | | -4 ADDED CHAMFER 45° AND LIMITS, CH'D DIM .996 TO .998 & P.F. -.7. | 6/8/2015 | RJC | |
| 6 | 17-0047 | -4 CH'D FINISH WAS BLACK OXIDE IS SEE -1 & -2. | 2/28/2017 | RJC | JAG |



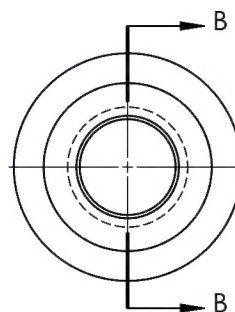
SECTION A-A



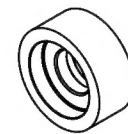
(-4)
PILOT
ROUGHING DETAIL



SECTION B-B



(-4)
PILOT
FINISHING DETAIL

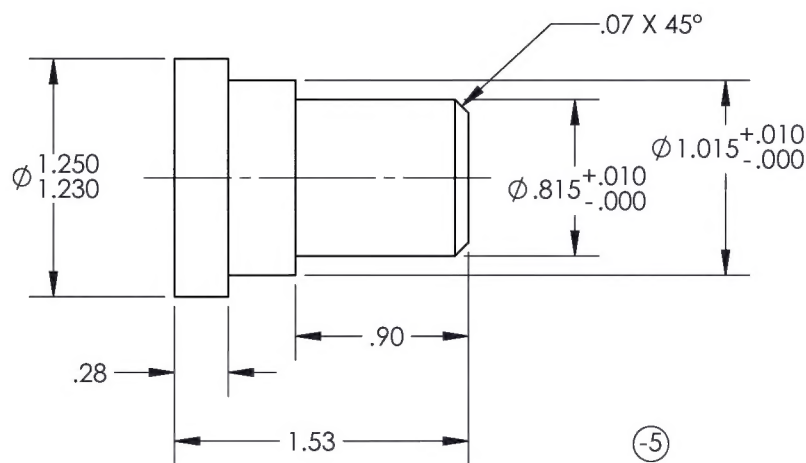


NOTE:
MUST MEET DIMENSIONAL LIMITS AFTER HEAT TREAT.

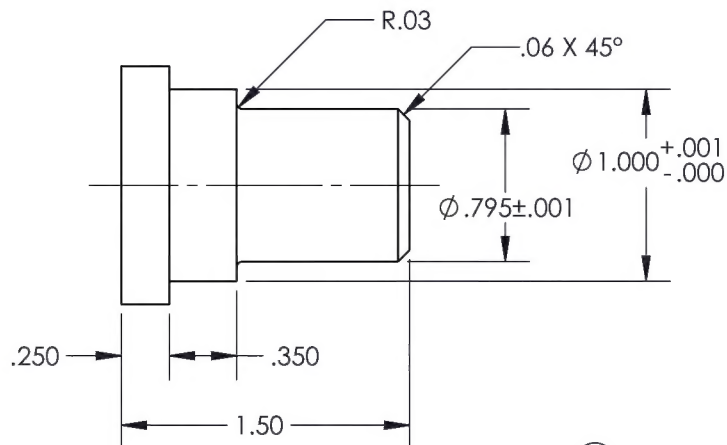
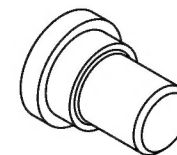
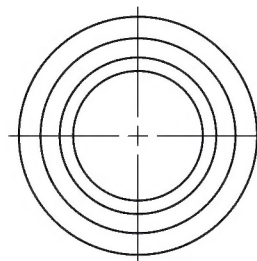
| | |
|--|--|
| DART AEROSPACE | |
| TITLE STAKING TOOL T/R PITCH CONTROL | |
| DWG NO. RB0006-809-00088-4 | REV 6 |
| MAT'L O-1 | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES |
| HEAT TREAT RC 55-60 | .XXX ± .005 FRACTIONS ± 1/8 |
| FINISH SEE -1 & -2 | .XX ± .01 ANGLES ± .5° |
| SPEC | .X ± .1 SURFACES = 125° ✓ |
| DRAWN BY: COLE | 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R |
| CHECKED: DUERFELDT | 2. DIMENSIONAL LIMITS APPLY AFTER PLATING |
| OPPS APPR: ANDERSON | 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 |
| QA APPR: LINDSAY | USED ON MODEL |
| APPROVED: GILBERT | MD 500 |
| SCALE 1:2 | DATE 12/10/2004 |
| SHEET 5 OF 7 | |

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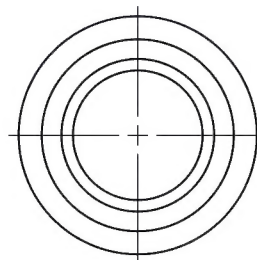
| REVISIONS | | | | | |
|-----------|---------|---|------------|---------|----------|
| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
| 1 | | -5 STEP OD REDUCED TO Ø.995. | 6/10/2004 | | |
| 4 | | CH'D -5 FINISH DETAIL FROM Ø.995 +.001 -.000 TO Ø1.000 +.001 -.000 PER G.E. | 10/24/2011 | RJC | RW |
| 6 | 17-0047 | -5 C'D DIM WAS .25 IS .28, WAS 1.50 IS 1.53, ADDED DIM 1.50, CH'D FINISH WAS BLACK OXIDE IS SEE -1. | 2/28/2017 | RJC | JAG |



(-5)
GUIDE
ROUGHING DETAIL



(-5)
GUIDE
FINISHING DETAIL

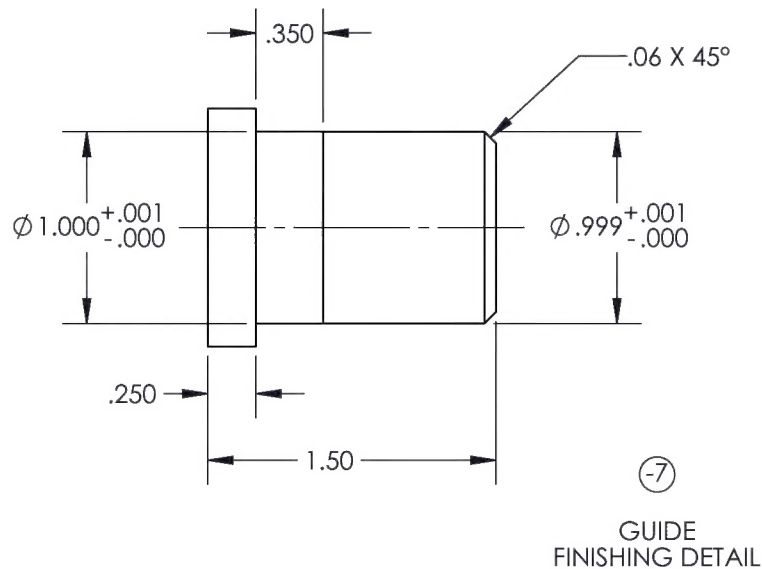
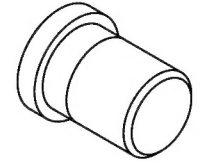
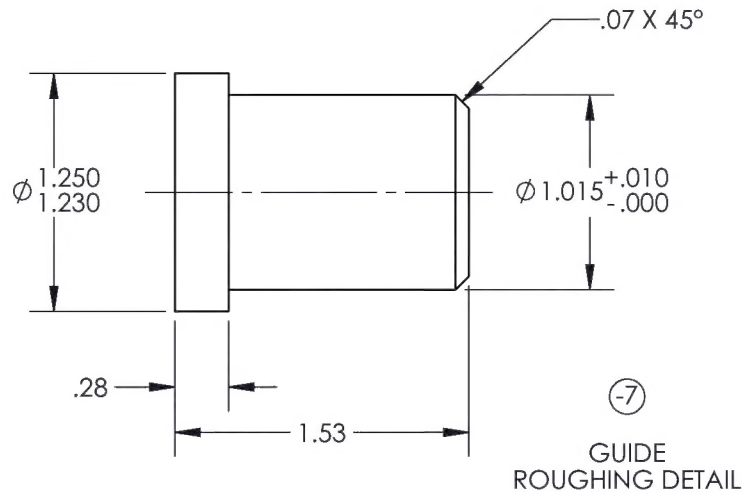


NOTE:
MUST MEET DIMENSIONAL LIMITS AFTER HEAT TREAT.

| | |
|---|------------------------------|
| DART AEROSPACE | |
| TITLE STAKING TOOL T/R PITCH CONTROL | |
| DWG NO. RB0006-809-00088-5 | REV 6 |
| MAT'L O-1 | UNLESS OTHERWISE SPECIFIED |
| HEAT TREAT RC 55-60 | DIMENSIONS ARE IN INCHES |
| FINISH SEE -1 | .XXX ± .005 FRACTIONS ± 1/8 |
| SPEC | .XX ± .01 ANGLES ± 5° |
| | .X ± .1 SURFACES = 125/✓ |
| DRAWN BY: COLE | 1. BREAK ALL SHARP EDGES |
| CHECKED: DUERFELDT | .015 x 45° OR .015R |
| OPPS APPR: ANDERSON | 2. DIMENSIONAL LIMITS APPLY |
| QA APPR: LINDSAY | AFTER PLATING |
| APPROVED: GILBERT | 3. INTERPRET DIM AND TOL PER |
| | ASME Y14.5M-2009 |
| SCALE 1:1 | DATE 12/10/2004 |
| | SHEET 6 OF 7 |

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| REVISIONS | | | | | |
|-----------|---------|---|------------|---------|----------|
| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
| 4 | | CH'D -7 FINISH DETAIL FROM Ø.998 +.001 -.000 TO Ø.999 +.001 -.000 & ADDED MISSING Ø1.000 +.001 -.000 P.F. -4 PER G.E. | 10/24/2011 | RJC | RW |
| 6 | 17-0047 | -7 CH'D DIM'S WAS .25 IS .28, WAS 1.50 IS 1.53, ADDED DIM'S .250, 1.50. CH'D FINISH WAS BLACK OXIDE IS SEE -2. | 2/28/2017 | RJC | JAG |



NOTE:
MUST MEET DIMENSIONAL LIMITS AFTER HEAT TREAT.

| | |
|--|------------------------------|
| DART AEROSPACE | |
| TITLE STAKING TOOL T/R PITCH CONTROL | |
| DWG NO. RB0006-809-00088-7 | REV 6 |
| MAT'L O-1 | UNLESS OTHERWISE SPECIFIED |
| HEAT TREAT RC 55-60 | DIMENSIONS ARE IN INCHES |
| FINISH SEE -2 | .XXX ± .005 FRACTIONS ± 1/8 |
| SPEC | .XX ± .01 ANGLES ± 5° |
| | .X ± .1 SURFACES = 125/✓ |
| DRAWN BY: COLE | 1. BREAK ALL SHARP EDGES |
| CHECKED: DUERFELDT | .015 x 45° OR .015R |
| OPPS APPR: ANDERSON | 2. DIMENSIONAL LIMITS APPLY |
| QA APPR: LINDSAY | AFTER PLATING |
| APPROVED: GILBERT | 3. INTERPRET DIM AND TOL PER |
| | ASME Y14.5M-2009 |
| | USED ON MODEL |
| | MD 500 |
| SCALE 1:1 | DATE 12/10/2004 |
| | SHEET 7 OF 7 |